



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3168-041
Job Sheet 209437



Part No: D3168-041

Job Qty: 1 pcs

Part Name: Step Assembly, Low Short LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/30/20

Job Tracking No:

Due Date: 5/20/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 16.01.14 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	1 pcs	5/19/20	5/19/20	0.00	0.10	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	QC 5	1 pcs	5/19/20	5/19/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S274857



Part: D3168-041

Job No: 209437

Serial No/Batch: S274857

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 04/30/20

DAS
24
9-89

Plex 4/30/20 10:02 AM Dart.lajeunesse.marie

130 Large Fab - Steps - 2 - B4B	1 pcs	5/19/20	0.00 0.20	QC 5 - 82	
				Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
140 QC 10	1 pcs	5/19/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	DAS
				QC 10 - 58	24
				QC 10 - 9	9-89
				QC 10 - 68	
				QC 10 - 81	
				QC 5 - 10	
150 QC 5	1 pcs	5/19/20	0.00 0.00	QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	24
				QC 5 - 49	9-89
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
160 Handfinish - 1-1 Chemical-B4B	1 pcs	5/19/20	0.00 0.10	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	

170 QC 7	1 pcs	5/19/20	0.00 0.00	Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	DAS
				QC 7 - 43	43
				QC 7 - 61	9-89
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
				QC 7 - 82	
				QC 7 - 87	
180 Large Fab - Steps - 3 - B4B	1 pcs	5/19/20	0.00 0.10	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	DAS
				Large Fab - 6 - B4B	43
				Large Fab - 7 - B4B	9-89
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
				QC 5 - 10	
				QC 5 - 12	
190 QC 5	1 pcs	5/19/20	0.00 0.00	QC 5 - 17	DAS
				QC 5 - 18	24
				QC 5 - 19	9-89

				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
200	Handfinish - 6-1- Touch Up- B4B	1 pcs	5/19/20	0.00 0.10	Handfinish - 6 - 1 - B4B
					Handfinish - 6 - 2 - B4B
					Handfinish - 6 - 3 - B4B
					Handfinish - 6 - 4 - B4B
					Handfinish - 6 - 5 - B4B
					Handfinish - 6 - 6 - B4B
					Handfinish - 6 - 7 - B4B
					Handfinish - 6 - 8 - B4B
					Handfinish - 6 - 9 - B4B
					Handfinish - 6 - 10 - B4B
					Handfinish - 6 - 11 - B4B
					Handfinish - 6 - 12 - B4B
					Handfinish - 6 - 13 - B4B
					Handfinish - 6 - 14 - B4B
					Handfinish - 6 - 15 - B4B
					Handfinish - 6 - 16 - B4B
					Handfinish - 6 - 17 - B4B
					Handfinish - 6 - 18 - B4B
					Handfinish - 6 - 19 - B4B
					Handfinish - 6 - 20 - B4B
					Handfinish - 6 - 21 - B4B
					Handfinish - 6 - 22 - B4B
210	Powdercoat - 1 White GI(A)- B4B	1 pcs	5/19/20	0.00 0.10	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
220	Handfinish - 3-1- WingWalk- B4B	1 pcs	5/20/20	0.00 0.10	Handfinish - 3 - 1 - B4B
					Handfinish - 3 - 2 - B4B
					Handfinish - 3 - 3 - B4B
					Handfinish - 3 - 4 - B4B
					Handfinish - 3 - 5 - B4B
230	QC 3	1 pcs	5/20/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51

BEB 20.05.13

20-05-13

Jul 20-5-11

DAS 34 9-88

					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	MAY 14 2020 40 9-89
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
290	Packaging 3-1 - Stock - B4B	1	5/20/20	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	DAS
					Packaging 3 - 25 - B4B	72
					Packaging 3 - 26 - B4B	9-89
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS
300	QC 21 - FG	1	5/20/20	0.00 0.00	QC 21 - FG - 21	21
	pcs				QC 21 - FG - 70	9-89
					QC 21 - SA - 53	MAY 14 2020

Part Op 110 - Fabricate per Drwg - 1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168. 2-Drill extrusion as per Dwg Descriptions: D3168 using Jig DT8680 for rivets.(Use only 1st 6holes). 3-Deburr.

120 - QC5- Inspect part completeness to step on W/O

130 - Weld per dwg A/R Aluminum rod Batch 130137-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8780, as per QSI 004 & Dwg D3168 A/R Aluminum Rod 130137 3- Grind end plate flush as per DWG.

140 - QC10- Inspect visual per QSI004- ground welds

150 - QC5- Inspect part completeness to step on W/O

160 - Chemical Conversion Coat per QSI005 4.1

170 - QC7-Inspect Chemical Conversion Coat

180 - (Fabricate per Drwg) Rivet Leg Assembly as per Dwg D3168 1-Bevel end for welding 2-Inspect for foreign object as per QSI 024 3-Weld end plate as per QSI 004 & Dwg D3168 A/R Aluminum Rod 14130137 4- Grind end plate flush as per dwg

190 - QC5- Inspect part completeness to step on W/O

200 - Touch up alodine

210 - White Gloss (B314.3.5.1) per QSI005 4.3-Alum) START TIME: 12:40 11254469 OVEN TEMPERATURE: 320°
FINISH TIME: 1:10

220 - Wing Walk as per dwg QSI005 4.4 Batch _____)

230 - QC3- Inspect Part Finish

290 - Identify as per dwg & Stock Location: _____

300 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	.5000 pcs (.5 ea)	110-Large Fab - Steps - 1	<u>5243427</u>
D3067-1	End Plate	1 pcs (1 ea)	110-Large Fab - Steps - 1	<u>5267468</u>
D3067-1	End Plate	1 pcs (1 ea)	180-Large Fab - Steps - 3 - B4B	<u>5267468</u>
D3077-1	Step Leg	2 pcs (2 ea)	180-Large Fab - Steps - 3 - B4B	<u>5081376</u> <u>5075314</u>
D3170-1	Spacer	2 pcs (2 ea)	180-Large Fab - Steps - 3 - B4B	<u>5108761</u>
D3219-5	Plate	2 pcs (2 ea)	180-Large Fab - Steps - 3 - B4B	<u>5077391</u>
MS20600-AD4W4	Rivet	12 Ea (12 ea)	180-Large Fab - Steps - 3 - B4B	<u>5251801</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	1	264	0
	D3067-1	1	76	0
180-Large Fab - Steps - 3 - B4B	D3067-1	1	76	0
	D3077-1	2	2	0
	D3170-1	2	12	0
	D3219-5	2	31	0
	MS20600-AD4W4	12	1,977	0

Part Specifications

Specifications could not be found.

Plex 4/30/20 10:02 AM Dart.lajeunesse.marie

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation		Disposition		Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Fit/Function ☐ Off-set/Set-up ☐									
		Other/Details:									